

Date: 7 Thursday, 5/10/2007 2:26:43 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 WEB
Job Number : 32291	
Estimate Number : 10466	
P.O. Number : N/A	Part Number : D33891
This Issue : 5/10/2007 S.O. No. : NA	Drawing Number : D3389 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : NA	Drawing Revision : C
Previous Run : 31897	Material : HWA
	Due Date : 5/30/2007
Written By : _____	Qty: 6 Um: Each
Checked & Approved By : <u>7.05.10</u>	
Comment : Est Rev:A 05.08.31 New issue KJ/JLM	
Est Rev:B 06-02-08 As per Rev C JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D25003100	Ext'n -1' Beam Web 4"
-----	-----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B25251

JB 7-5-14

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1  
 1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

PTO

JB 7-5-14

3.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

DD

7-5-14

6

PTO

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

JB 7-5-14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/05/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070515	260	0.257" hole was drilled at the 8th hole from the first section of the I-beam. Should have been drilled at the 11th hole. 6 webs drilled the same.	Q51042	open the 0.257" hole to 0.625" as per Dwg.	JD 7-5-16			
				retrain employee to fully understand the Dwg.	JD 7-5-16	7-5-22	Q51042	070515

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:26:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 32291

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-5-16

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

JD 7-5-16 (6)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/22

Job Completion



CY07/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

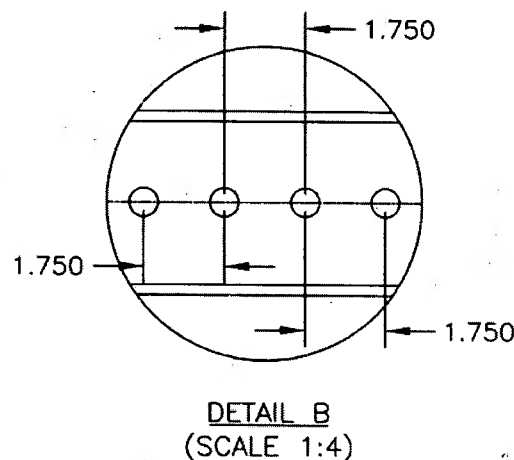
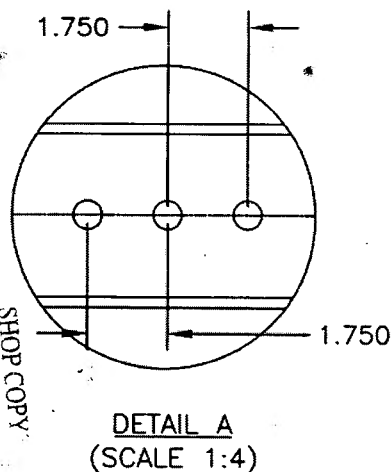
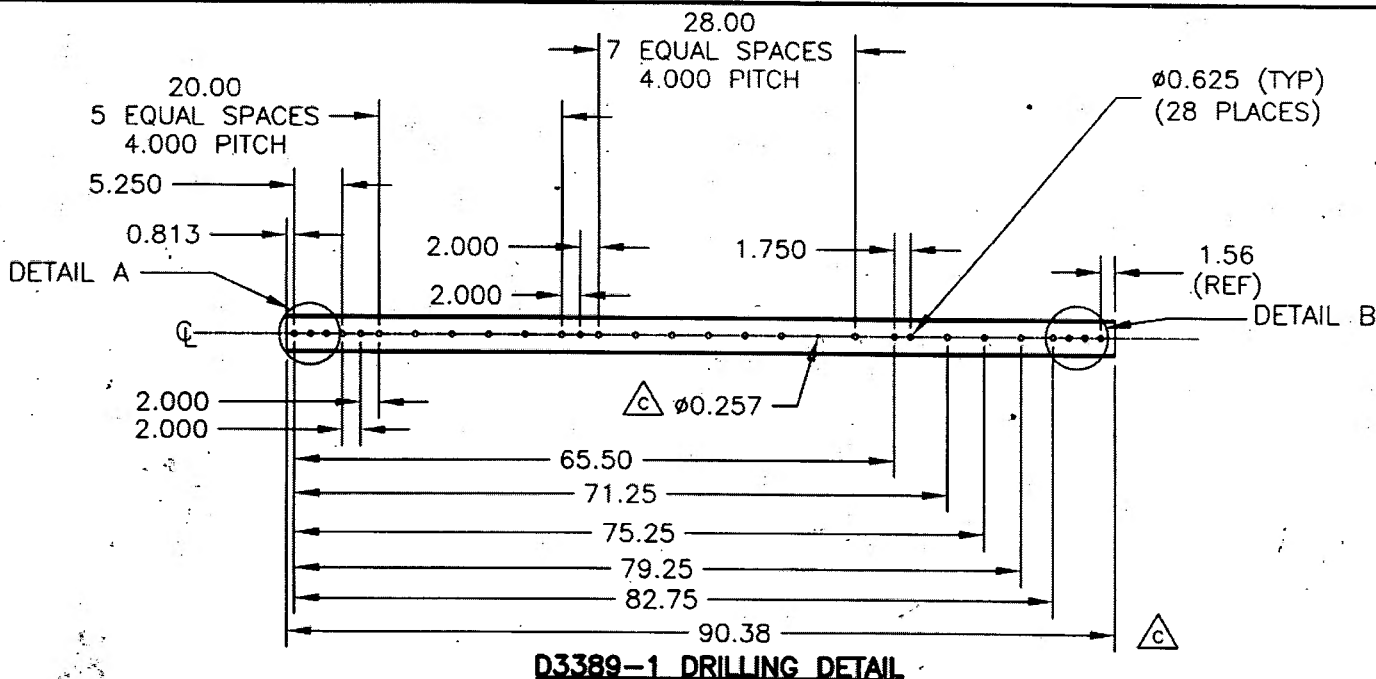
NOTE: Date & initial all entries

# DART

RELEASE

06.01.27

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.		REV. C
CHECKED		APPROVED		DRAWING NO.	D3389	SHEET 1 OF 1
DATE	06.01.23			TITLE	412 WEB	
A	05.02.07			NEW ISSUE		
B	05.06.13			UPDATE DIMENSIONING		
C	06.01.23			DECREASE OVERALL LENGTH, MODIFY HOLE		



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
\*SUBJECT TO AMENDMENT  
WITHOUT NOTICE

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2005 by DART AEROSPACE USA, INC.